

Work Order ID 131728

Tuesday, April 21, 2015 1:48:05 PM

131728

Page 1

Item ID: D2891-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Support 2.25
 Start Date: 4/20/15 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2891	B								

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA046
2-Deburr

0.00

0.07

15-05-06

10

0

JFC 2015-05-04
JFC 2015-05-07

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

15-05-06

10

0

JFC 2015-05-04
JFC 2015-05-07

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

10

0

DAS
14
9-89

1505109

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Tuesday, April 21, 2015 1:48:05 PM

131728

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180

QC21 - Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

MLJ

MAY 12 2015

Quality Control

WIE

15-5-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																									

Picklist Print

Tuesday, April 21, 2015 1:48:05 PM

Page 1

Work Order ID: 131728

131728

Parent Item: D2891-1

D2891-1

Parent Item Name: Support 2.25

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP C02.11.26Added P/OKJ

IPP D 08.03.19 Re-format EC verified: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK076		Manufactured	No			110	Each	12.0000	0.5	5			

DSK076

D2891-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

12

113931

1

116430

1

119736

10

1
1
3 } JFL 2015-05-04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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DART AEROSPACE LTD		Work Order:	131728
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.191	0.191	0.191	0.191	0.191
AB	0.240	0.260		0.250	0.248	0.250	0.251	0.248
AC	0.115	0.150		0.125	0.123	0.125	0.125	0.125
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.302	0.300	0.302	0.302
AH	0.115	0.150		0.140	0.138	0.140	0.140	0.139
AI	0.454	0.474		0.467	0.467	0.466	0.466	0.455
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.036	1.033	1.040	1.036	1.039
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.258	0.258	0.258	0.258	0.258
AO	1.663	1.683		1.677	1.676	1.676	1.677	1.665
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JFL 1505-06 JFL 2015-05-07 **Date:** 2015-05-04

Audited by: DAS 14 **Date:** 15/05/09

Preliminary Approval: 9-89 **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 131728
Description: Ø2.250 Support		Part Number: D2891-1
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FIRST ARTICLE INSPECTION DIMENSION SHEET

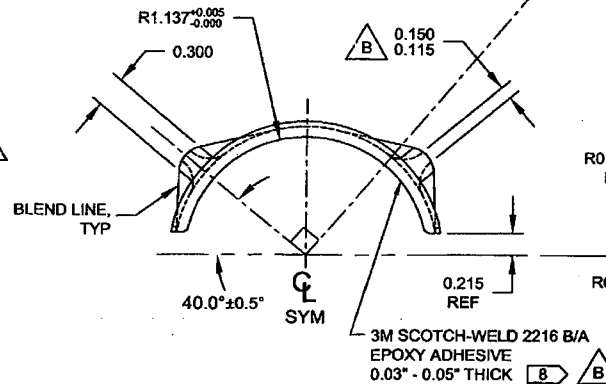
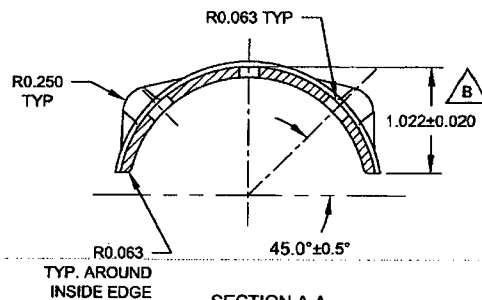
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	8/10
HAAS Section								
AA	0.188	0.193		0.191	0.191	0.191	0.191	0.191
AB	0.240	0.260		0.2463	0.247	0.2465	0.250	0.248
AC	0.115	0.150		0.126	0.126	0.126	0.126	0.126
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.139	0.139	0.139	0.139	0.140
AI	0.454	0.474		0.455	0.462	0.465	0.469	0.468
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.038	1.035	1.035	1.035	1.038
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.258	0.258	0.258	0.258	0.258
AO	1.663	1.683		1.663	1.677	1.678	1.680	1.680
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
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Measured by: Jfe	Date: 2015-05-07
Audited by: DAS 14 9-89	Date: 15/05/09
Preliminary Approval:	Date:

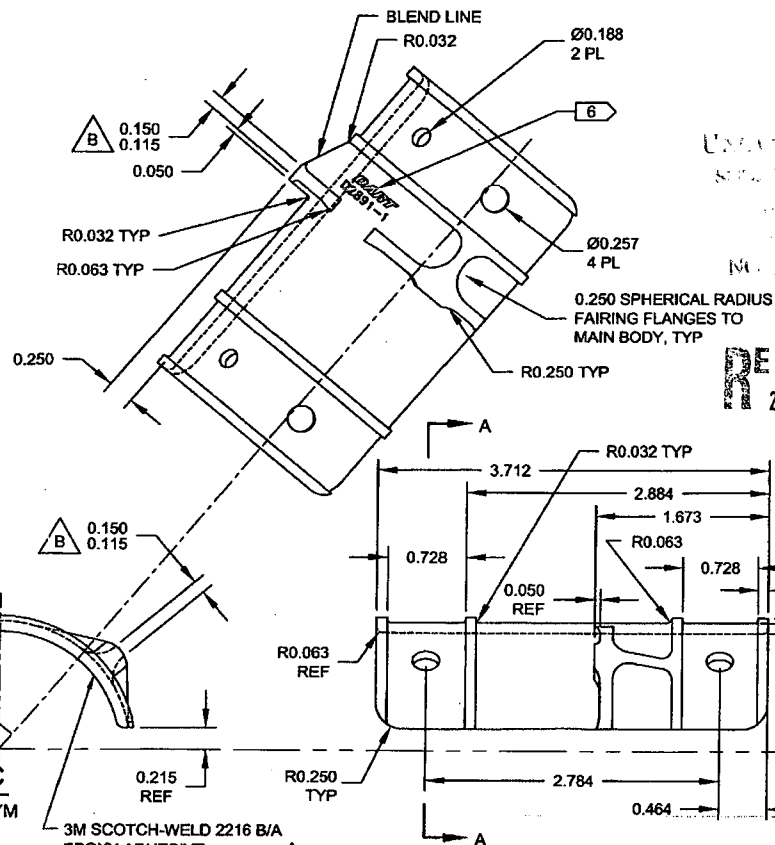
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A	02.12.12	New Issue	KJ/RF	
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C	12.09.26	Dwg Rev updated	KJ	

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.38 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



D2891-1 SUPPORT



RELEASED
2011-07-28

B	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION, UPDATE TOLERANCE (ZN D4-1,B4-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2891
TITLE Ø2.250 SUPPORT
REV. B
SHEET 1 OF 1
SCALE NTS

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